

Work Order ID 77112

77112

Page 1

November-25-11 1:38:41 PM

Item ID: D3642-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 25/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3642	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet **Memo** 0.00 B12-3-9
 FLOW CNC Waterjet 1-Cut as per Dwg D3642 Dwg Rev: B Prog Rev: B 2- 7
2024.86 Debur if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC **Memo** 0.00 B12-3-9
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC **Memo** 0.00 8.21/3/11 47
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 25/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

7X Ø M/L 12/03/15

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

7 Ø M/L 12/03/15

150

Identify as per dwg & Stock Location: ST 244 0.00

150

Packaging

Memo

0.00

Packaging

7X Ø M/L 12-03-16

W/O:		WORK ORDER CHANGES					
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Work Order ID 77112***77112***

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Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 6.00

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Customer:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

12/3/16 

112-03-16

Dart Aerospace Ltd

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Picklist Print

November-25-11 1:38:45 PM

Page 1

Work Order ID: 77112

77112

Parent Item: D3642-1

D3642-1

Parent Item Name: Doubler

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

70.1000

0.1664

1.050947

M2024T3S 050

**

B12-3-9

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

70.1

117684

70.1

117684

7

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DART AEROSPACE LTD		Work Order:	77112
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.126	2		✓ BoZ	
Ø0.098	+0.004/-0.001	.098	2		✓	
0.35	+/-0.030	.351	2		✓	
1.25	+/-0.030	1.247	2		✓	
1.700	+/-0.010	1.700	2		✓	
2.15	+/-0.030	2.153	2		✓	
3.05	+/-0.030	3.054	2		✓	
3.95	+/-0.030	3.949	2		✓	
4.078	+/-0.010	4.077	2		✓	
4.85	+/-0.030	4.851	2		✓	
5.20	+/-0.030	5.205	2		✓	
0.343	+/-0.010	.343	2		✓	
0.40	+/-0.030	.400	2		✓	
1.30	+/-0.030	1.303	2		✓	
3.35	+/-0.030	3.353	2		✓	
3.47	+/-0.030	3.470	2		✓	
3.79	+/-0.030	3.79	2		✓	
3.959	+/-0.010	3.963	2		✓	
4.08	+/-0.030	4.084	2		✓	
4.60	+/-0.030	4.610	2		✓	
1.537	+/-0.010	1.539	2		✓	
3.28	+/-0.030	3.283	2		✓	
3.80	+/-0.030	3.808	2		✓	
3.915	+/-0.010	3.912	2		✓	
0.450	+/-0.010	.451	2		✓	
4.066	+/-0.010	4.068	2		✓	
4.20	+/-0.030	4.198	2		✓	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-3-9	Date: 12/17/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	
B	08.12.01	Dimensions updated per Dwg Rev. B	KJ/EC	

Dart Aerospace Ltd

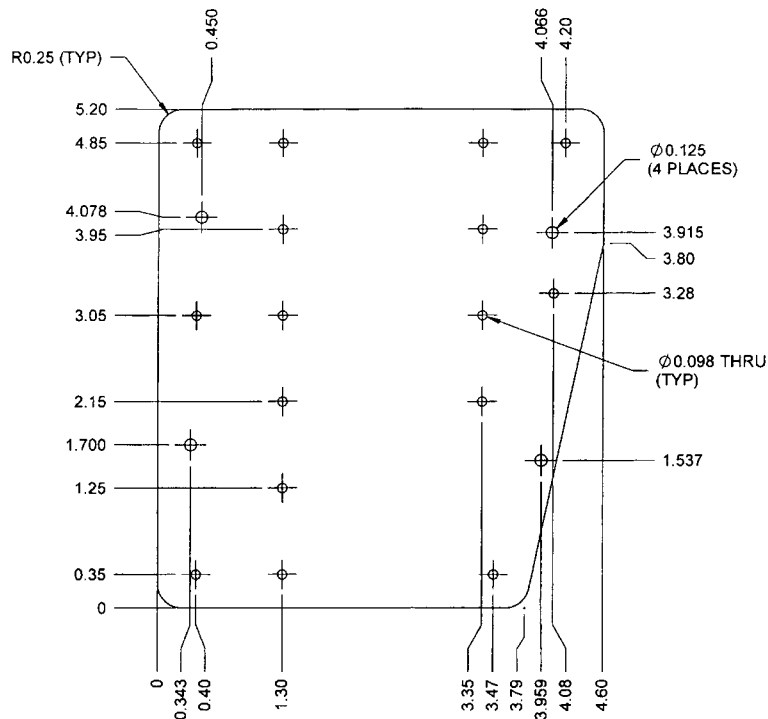
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D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2) B

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 012 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AGREEMENT
WITHOUT NOTICE
WORK ORDER
NO. 77-112 M.C.J
11/11/25



RELEASED
07.10.16

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE, REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3642 REV. B SHEET 1 OF 1 TITLE DOUBLER SCALE 4:5 <small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	LE		
CHECKED	TS		
MFG. APPR.	TS		
APPROVED	TS		
DE APPR.	TS		
DATE	07.10.16		

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